



A-1674

**Abstract of the Invention**

A quick change roll-fed high speed labeling system for improving labeling speed and precision label placement comprises a conveyor for moving articles to be labeled, and an infeed screw assembly for spacing and stabilizing the articles. The infeed screw assembly comprises a feedscrew having a plurality of pockets for

- 5 receiving and properly spacing successive incoming articles, which has a gear drive, and means for pivoting the feedscrew both vertically and horizontally. Additional system elements include a rotatable starwheel assembly having a plurality of spaced pockets for receiving individual ones of the articles therein, a rotatable vacuum drum assembly, and a supply of roll fed labels, wherein the labels are dispensed
- 10 singly onto a label receiving face of the rotatable vacuum drum assembly. The rotatable vacuum drum assembly comprises a unique three-ported valving system, for reducing or eliminating glue clogging problems during system operation.

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